

Work Order ID 88645

July-30-12 10:16:58 AM

88645

Page 1

Item ID: D3914-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Rib

Start Date: 27/07/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 10/08/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/02/30

Tooling:

Date:

Run Start ***NR1***

QC: _____

Date: _____ SPC (Y/N): _____

Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3914	B								
100		0.00							
100									
Large Fab	Memo	0.00							
Large Fab	1- Cut tube as per dwg D3914 2- debur and remove identification markings								
110	QC6- Inspect dimensions to drawing	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	Identify as per dwg & Stock Location: <u>WA.004</u>	0.00							
120									
Packaging	Memo	0.00							
Packaging									

13 13-03-04 PD

10 13-03-04

10 13-03-04 PD

Work Order ID 88645***88645***

Page 2

July-30-12 10:16:58 AM

Item ID: D3914-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Rib

Stop ***NS2***

Start Date: 27/07/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 10/08/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

13/4/5

113-03-5

Picklist Print

July-30-12 10:17:02 AM

Page 1

Work Order ID: 88645

Parent Item: D3914-1

Parent Item Name: Rib

88645

D3914-1

Start Date: 27/07/2012

Required Date: 10/08/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B
as per dwg revB DD 10.08.18 verified by:EC IPP Rev:C 11.01.18 chg
qc5 to 6 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TS0.750W.049		Purchased	No			100	f	322.4533	8	33.68421			

M304TS0 750W 049

304 SQ Tube .75x.75x.049W

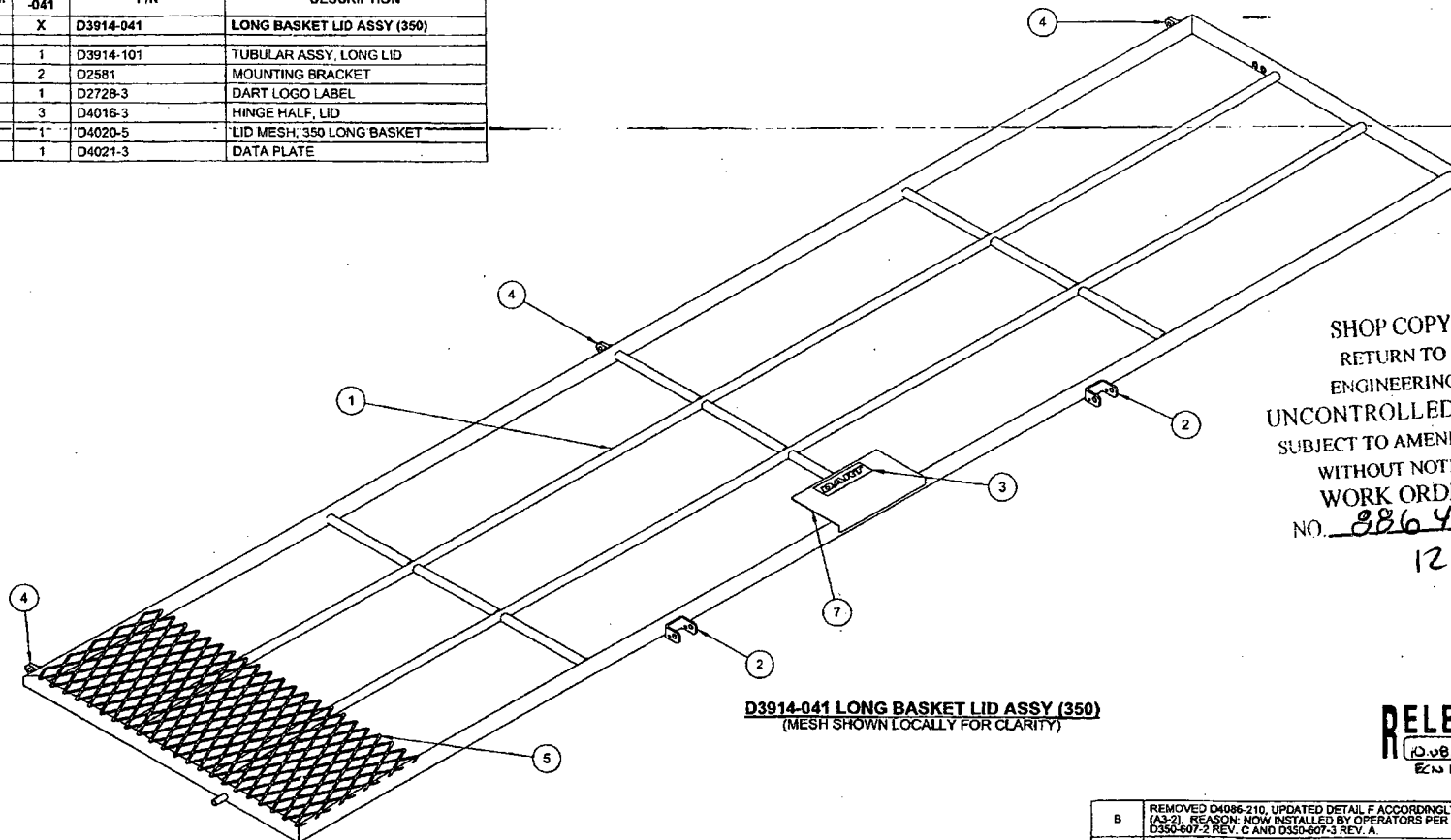
**

13-03-05 DD

Location	Loc Qty	Loc Code
MAT017	1.0078107	
121898	1.0078107	
MAT018	320.3829959	
119147	2	
119643	3.30639585	
121439	12.45	
122201	2.6266	
122425	300	
WA034	1.0625	
121087	1.0625	

M123484 -> 84.2105

ITEM	QTY	P/N	DESCRIPTION
	X	D3914-041	LONG BASKET LID ASSY (350)
1	1	D3914-101	TUBULAR ASSY, LONG LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	3	D4016-3	HINGE HALF, LID
6	1	D4020-5	LID MESH, 350 LONG BASKET
7	1	D4021-3	DATA PLATE



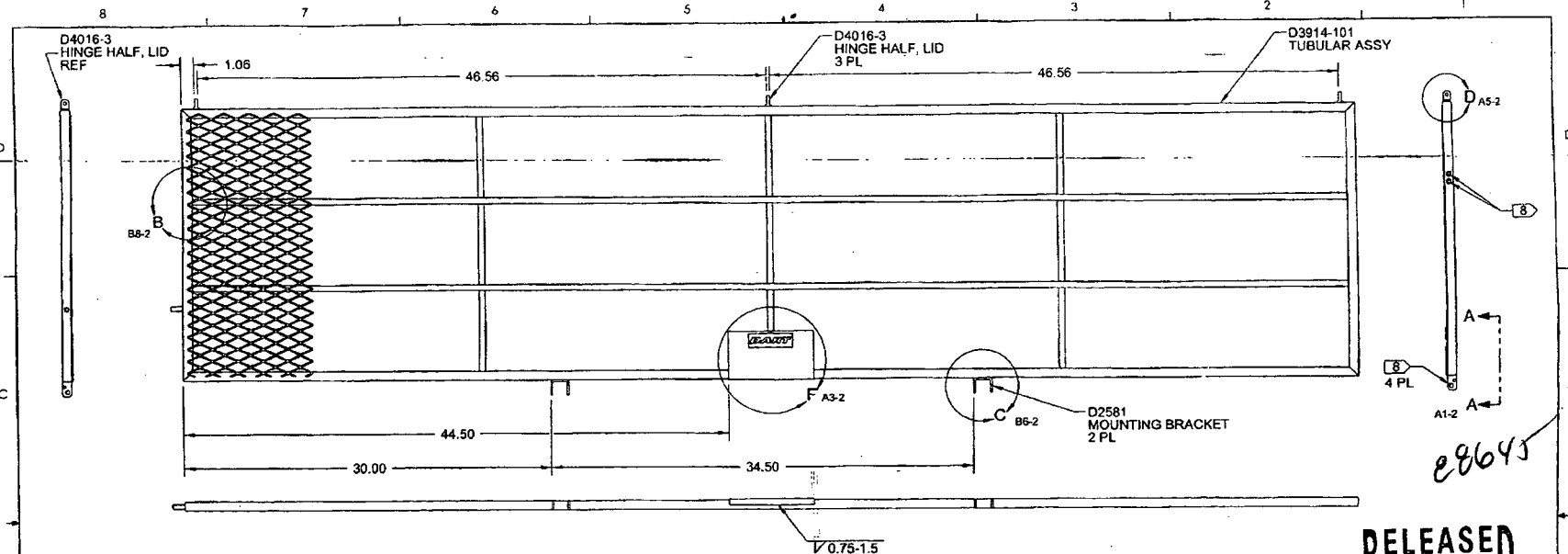
D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 88645 MLJ

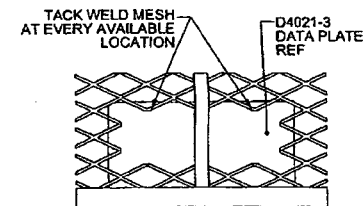
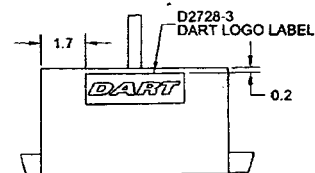
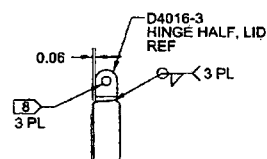
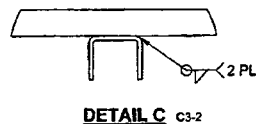
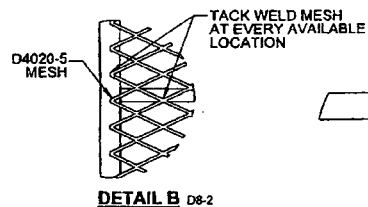
12/07/30

RELEASED
10.08.17
ECN 10-596

B	REMOVED D4086-210, UPDATED DETAIL F ACCORDINGLY (A3-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A	MB	10.08.05
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	SC	DRAWING NO. D3914	REV. B
MFG. APPR.	AS	SHEET 1 OF 4	
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	LONG BASKET LID ASSY (350)	NTS
DATE	10.08.05	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR ANY COMMUNICATIONS TO ANY OTHER PERSONS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)



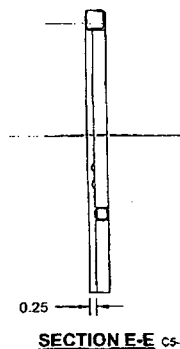
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.35 lbs APPROX
- 8) MASK HOLES PRIOR TO FINISHING
- 9) WELD PER DART QSI 004

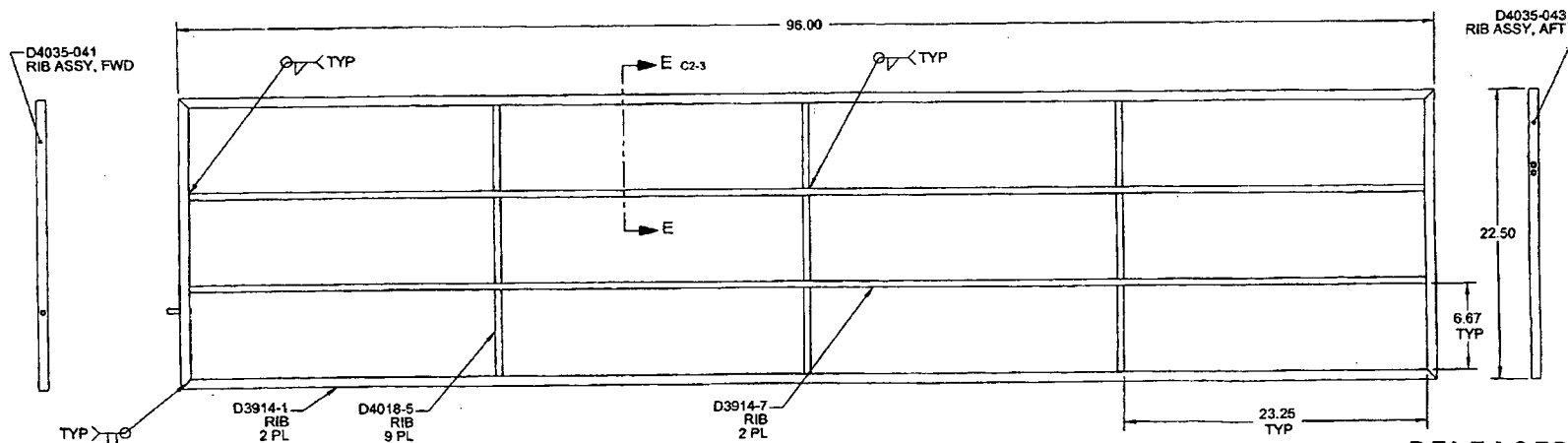
DESIGN	ALS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV.
MFG. APPR.		D3914	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET LID ASSY (350)	NTS
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND IS AVAILABLE FOR RELEASE TO THE PUBLIC WITHOUT LIMITATION. IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATION TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	

RELEASED
10.08.05

ITEM	QTY -101	P/N	DESCRIPTION
	X	D3914-101	TUBULAR ASSY, LONG LID (350)
1	2	D3914-1	RIB
2	2	D3914-7	RIB
3	9	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT



086045

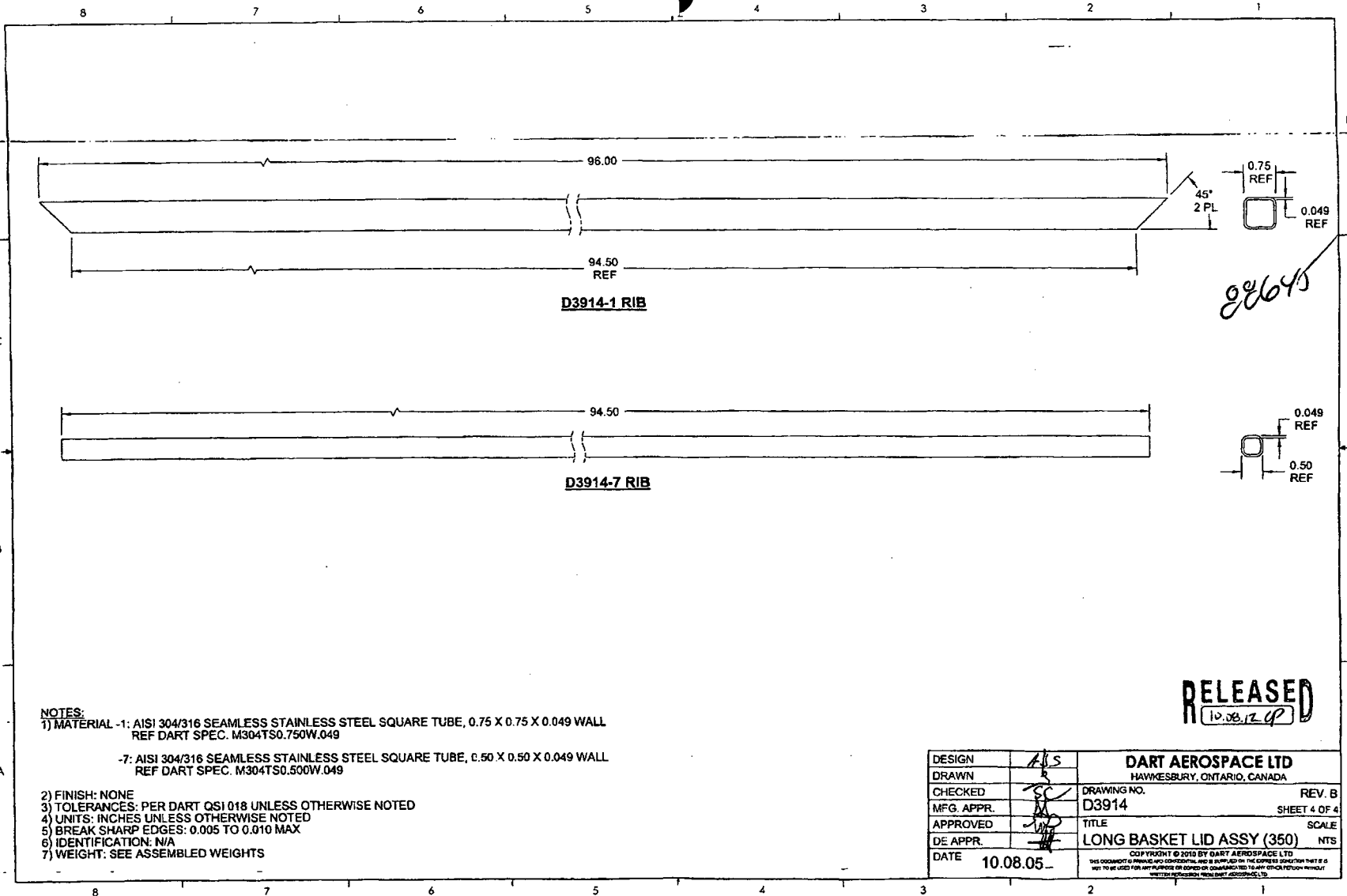


8 D3914-101 TUBULAR ASSY, LONG LID

RELEASED
10-08-12

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 14.10 lbs
 - 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4018-101
 - 9) WELD PER DART QSI 004

DESIGN	ALS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	BC	DRAWING NO. D3914	REV. B
CHECKED	W	SHEET 3 OF 4	
MFG. APPR.	W	TITLE LONG BASKET LID ASSY (350)	SCALE NTS
DE APPR.	W	COPYRIGHT © 2010 BY DART AEROSPACE LTD. THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.08.05		



DESIGN	ABS	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. B
MFG. APPR.	SC	D3914	SHEET 4 OF 4
APPROVED	SC	TITLE	SCALE
DE APPR.	SC	LONG BASKET LID ASSY (350)	NTS
DATE	10.08.05	COPY RIGHT © 2010 BY DART AEROSPACE LTD	

Receiving Report

Date:

12/10/29

Batch No:

m12 3489

Supplier:

Metaxsation

Dart P/O:

18214

Packing Slip:

Yes

☒

No

☐

Invoice:

Yes

☒

No

☒

Receipt:

Cash

☐

Cr

☒

Release Note Attached:

Yes

☒

No

☐

N/A

Waybill Attached:

Yes

☒

No

☐

N/A

Shipment Complete:

Yes

☒

No

☐

N/A

QC6 Inspection

☒

12/11/21

☐

N/A

Work Order

☒

12/11/21

☐

N/A

☒

N/A

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12

Production/Admin:

Date

Received/Costing

Initial

12/10/29
[Signature]

Location

Purchase Order Receipt Listing

Page 1 of 1

Monday, October 29, 2012 9:29:38 AM

All amounts are calculated in domestic currency.

All Vendors PO ID PO18214 All Receipt Dates All Line Item Types
All Item ID/GL/WOs All Rec. Employees All Currencies
Grouped by Vendor ID

Purchase Order ID/ Curr Type	Line Nbr/ Insp Req	Project ID	Reference/ Description/ Cert Std	PO U/M / Stock U/M	Required Date Required Qty	Recv Date/ Recv Emp	Recv Qty (PO U/M)	Cost Per Unit/ Recv Value	Inspected Qty/ Rejected Qty (PO U/M)	MRB Qty/ MRB Reject Qty	Book Amt
------------------------------------	-----------------------------	------------	--	-----------------------	-------------------------------	---------------------------	-------------------------	------------------------------	--	-------------------------------	----------

VendorID\Vendor Name	VC-MET002	Metaux Solutions									
PO18214	1		M304TS0.750W.049 f		10/29/2012	10/29/2012	600.0000	\$3.86	0.0000	0	\$2,318.99
CAD	No		304 SQ Tube f		600.0000	DESJ02		\$2,318.99	0.0000	0	
			.75x.75x.049W								
			123484								

Total Received Quantity:	600.0000
Total Qty to Inspect (PO U/M):	0.0000
Total Reject Quantity:	0.0000
Total Receipt Value:	\$2,319.00
Total Balance Due Quantity:	0.0000

MÉTAUX SOLUTIONS INC
2625 BOUL JACQUES CARTIER EST
LONGUEUIL, QUEBEC
J4N 1L7 Tel : 450 641-3330

Customer : 6323336

DART AEROSPACE LTD
1270, ABERDEEN STREET
HAWKESBURY, ONTARIO
K6A 1K7

Shipping Order 25/10/2012

Order : 82133
Reference : PO18214
Ship : PICK UP / PICK UP

Ship To

Same

Tel.: 1 613 632-3336

Item No.	Description	Qty	Qty. Delivered	B/O Qty
SSQT34340494	304 SQ TUBE .750 X .049 WALL 30 X 20' HT,C5P3	600	600	Ø

SHIP TST COLLECT
JP

DAS
14
2-8 12/11/01

Leopold

Shipping : _____

Package No : _____

Merchandise Received: _____

Ref. : _____

PHOENIX TUBE COMPANY, INC.
 Manufacturer of Stainless Ornamental and Structural Tubing
CERTIFICATION OF TEST

Sold To:

Ship To:

CUSTOMER ORDER#: C85485
 CUST REF NBR:
 DATE SHIPPED: 10/22/12
 SIZE: 3/4SQ X 18 GA AW
 SOURCE: USA D
 VENDOR: NAS

Phone# 5492803 Ext:
 ORDER#: 288601
 QTY SHIPPED: 1520.0
 GRADE: 304L WELD: HF
 HEAT#: C8P3
 TEST REPORT#: TR010484
 Report Date: 07/10/12

Specification:

ASTM A584-11	T304L/304 DUAL CERTIFIED	NO WELD REPAIR	EN 10204 2.2
ASTM-A 240 LATEST REVISION	RAW MATERIAL SPEC.		NACE MR0175/D1
ASTM A554 2003 SUPERSEDED	MFG USING	ANNEALED AND PICKLED	PLATE, SHEET OR STRIP
MATERIAL IS FULL SOLUTION	ANNEALED, AND SHOWS NO	CONTINUOUS CARBIDE	PRECIPITATION
DFARS 252.225-7009/7014	COMPLIANT		

DAS
 14
 2-89 12/11/01

MERCURY IS NOT USED BY US AS AN ALLOYING MATERIAL NOR IS METALLIC MERCURY HANDLED IN THE VICINITY OF OUR PROCESSING LINES. WE ARE NOT PRESENTLY AWARE OF ANY MERCURY CONTAMINATION.

Chemical Analysis

C	MN	P	S	SI	CR	NI	MO	CU	CO	N2	TI
.021	1.77	.032	.012	.27	18.22	8.08	.33	.43	0	.08	0

Physical Analysis

Hardness	YIELD		TENSILE		OTHER	
	PSI	MPA	PSI	MPA	Percent EL	Percent RA
RB 86	50460	0	96110	0	45	0

THE CHEMICAL ANALYSES ARE CORRECT AS CONTAINED IN OUR CORPORATE RECORDS.
 PHYSICAL PROPERTIES ARE DETERMINED WHILE MATERIAL IS IN STRIP FORM.
 Melted & Manufactured in the USA FAR BAA complies, DFARS BAA complies, FAR TAA complies

CERTIFIED BY:

San Lerao

1185 WIN DR, BETHLEHEM, PA, 18017 - (610) 865-5337
 FAX NUMBER: 610-865-4073

149135



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PO REPRINT

Purchase Order ID PO18214

Purchase Order Date 10/23/2012

PO Print Date 10/29/2012

Page Number 1 of 1

Order From :

METAUX SOLUTIONS
2625 BOUL JACQUES-CARTIER EST
LONGUEUIL, QC J4N 1L7
CA

VC-MET002

REFERENCE ONLY

Contact Name

Vendor Phone 800 558 8858

Vendor Fax 514 633 8044

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	M304TS0.750W.049	304 SQ Tube .75x.75x.049W	10/29/2012	600.00	TST ground	\$3.8000	\$2,280.00

Yes

Special Inst:

AISI 304/316 SEAMLESS SS
SQUARE TUBING
ASTM A554 MILL FINISH OR
ASTM A269 MILL FINISH

PO Total:

\$2,280.00

REFERENCE ONLY

Change Nbr: 1

Change Date: 10/23/2012

No substitution or deviation without
consent.

Certificate of Conformity or Material
Certification required - YES NO